

# Work Order ID 74026

Tuesday, September 20, 2011 1:08:56 PM



Page 1

Item ID: D3213-1

Accept



Setup Start



Revision ID:

Item Name: Door Panel

Stop



Start Date: 9/20/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/3/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

*10-9-20*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3213

B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3213 ☒ Dwg Rev: *B* ☐ Prog Rev: *B* ☐ 2-

Deburr if necessary

*10-10-28*

*10-10-26*

*(10)*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*10-10-26*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*5-10-28*

*(10)*

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
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**NOTE:** Date & initial all entries

**Work Order ID 74026**

Tuesday, September 20, 2011 1:08:56 PM



Page 2

Item ID: D3213-1

Accept



Setup Start



Revision ID:

Item Name: Door Panel

Stop



Start Date: 9/20/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/3/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description                | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130<br><br>Small Fab           | Small Fab                               | 0.00                 |         |        |              |               |               |                  |                |
| Small Fab                      | Memo                                    | 0.00                 |         |        |              |               |               |                  |                |
| Small Fab                      | Deburr                                  |                      |         |        |              |               |               |                  |                |
|                                | <i>u/45</i>                             |                      |         |        |              |               |               |                  |                |
| 140<br><br>HandFinish          | Chemical Conversion Coat per QSI005 4.1 | 0.00                 |         |        |              |               |               |                  |                |
| Hand Finishing                 | Memo                                    | 0.00                 |         |        |              |               |               |                  |                |
|                                |   |                      |         |        |              |               |               |                  |                |
| 150<br><br>QC                  | QC3- Inspect Part Finish                | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                | Memo                                    | 0.00                 |         |        |              |               |               |                  |                |

*10 BL 11-10-21**10 XPM 11/10/31*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 74026**

Tuesday, September 20, 2011 1:08:56 PM



Page 3

Item ID: D3213-1

Accept



Setup Start



Revision ID:

Item Name: Door Panel

Stop



Start Date: 9/20/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/3/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description                        | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160<br>                        | Identify as per dwg & Stock Location: <u>22</u> | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                      | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                      |   |                      |         |        |              |               |               |                  |                |
| 170<br>                        | QC21- Final Inspection - Work Order Release     | 0.00                 |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |

11/10/31

100

11/11/01

mf 11-10-31

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, September 20, 2011 1:09:01 PM

Page 1

Work Order ID: 74026



Parent Item: D3213-1



Parent Item Name: Door Panel



Start Date: 9/20/2011

Required Date: 10/3/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 05-11-17 New Issue JLM  
IPP Rev:B 07-02-13 Now on Waterjet JLM  
IPP Rev C: 08.11.26 Comment added to step 2 KJ Verified by: EC

| Component Item ID/<br>Item Name   | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit   | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|--------------|---------------|----------------|--------|
| M2024T3S.063<br><br>2024-T3 .063 sheet |                        | Purchased     |             | No                  |                  | 100             | sf                 | 116.5000       | 0.4714  | 4.962105     |               |                |        |
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|   |                        |               |             |                     |                  |                 |                    |                |   |              |               |                |        |

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

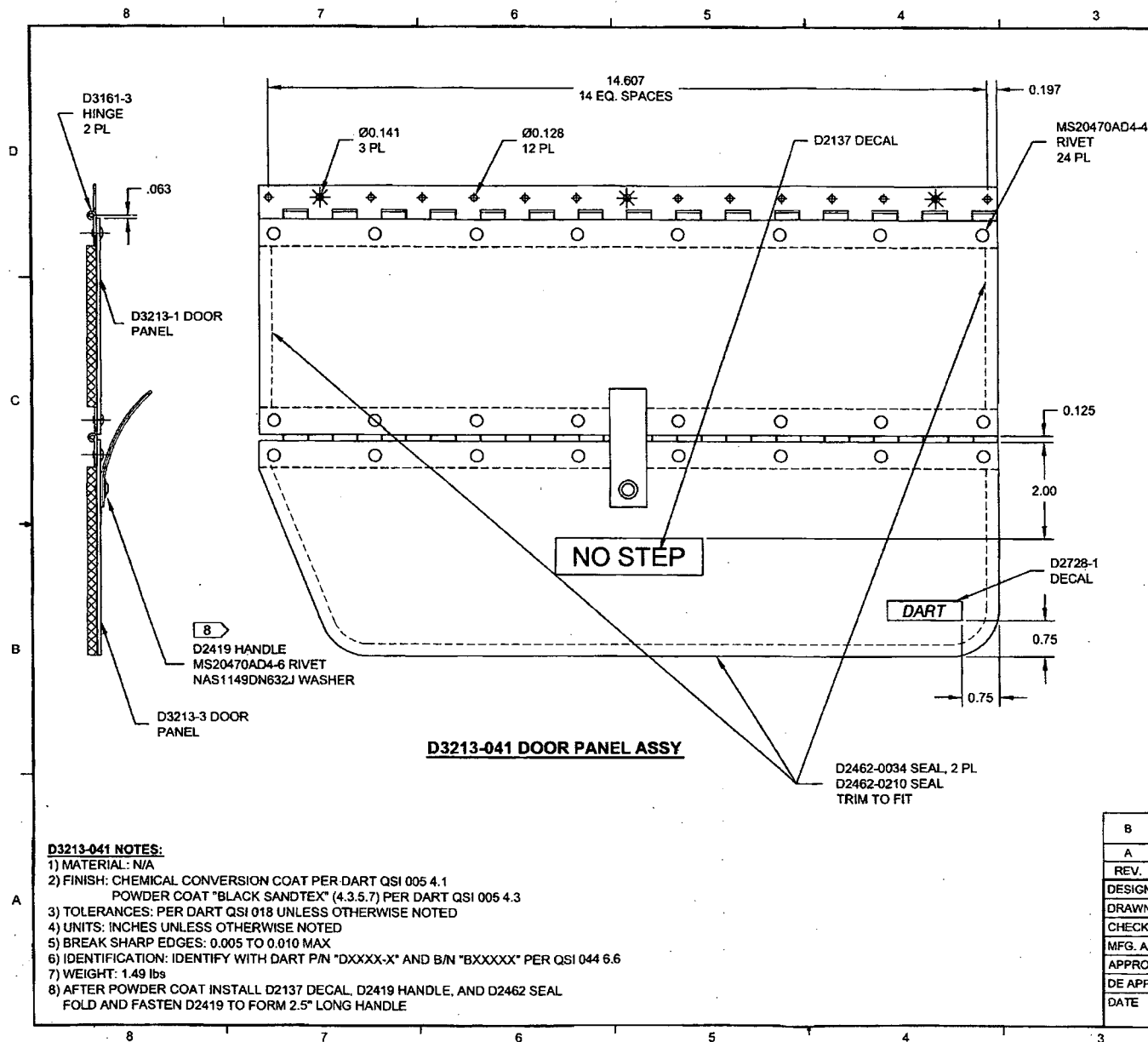
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries







| QTY  | PART NUMBER   | DESCRIPTION          |
|------|---------------|----------------------|
| -041 |               |                      |
| X    | D3213-041     | DOOR ASSEMBLY        |
| 1    | D2419         | HANDLE               |
| 2    | D2462-0034    | SEAL                 |
| 1    | D2462-0210    | SEAL                 |
| 1    | D2728-1       | DECAL                |
| 1    | D2137         | DECAL                |
| 2    | D3161-3       | HINGE                |
| 1    | D3213-1       | DOOR PANEL           |
| 1    | D3213-3       | DOOR PANEL           |
| 1    | NAS1149DN632J | WASHER (OR AN960JD6) |
| 24   | MS20470AD4-4  | RIVET                |
| 1    | MS20470AD4-6  | RIVET                |

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 74026

RELEASED  
2011-06-14

|            |   |    |          |
|------------|---|----|----------|
| B          | FORMAT TO CURRENT STD: ADD D3213-041B<br>REASON: PAR11-109. | MB | 11.06.06 |
| A          | NEW ISSUE   | CP | 03.09.03 |
| REV.       | DESCRIPTION   | BY | DATE     |
| DESIGN     |   |    |          |
| DRAWN      |   |    |          |
| CHECKED    |   |    |          |
| MFG. APPR. |   |    |          |
| APPROVED   |   |    |          |
| DE APPR.   |   |    |          |
| DATE       | 11.06.06  |    |          |

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B  
D3213 SHEET 1 OF 4  
TITLE SCALE  
DOOR ASSEMBLY NTS

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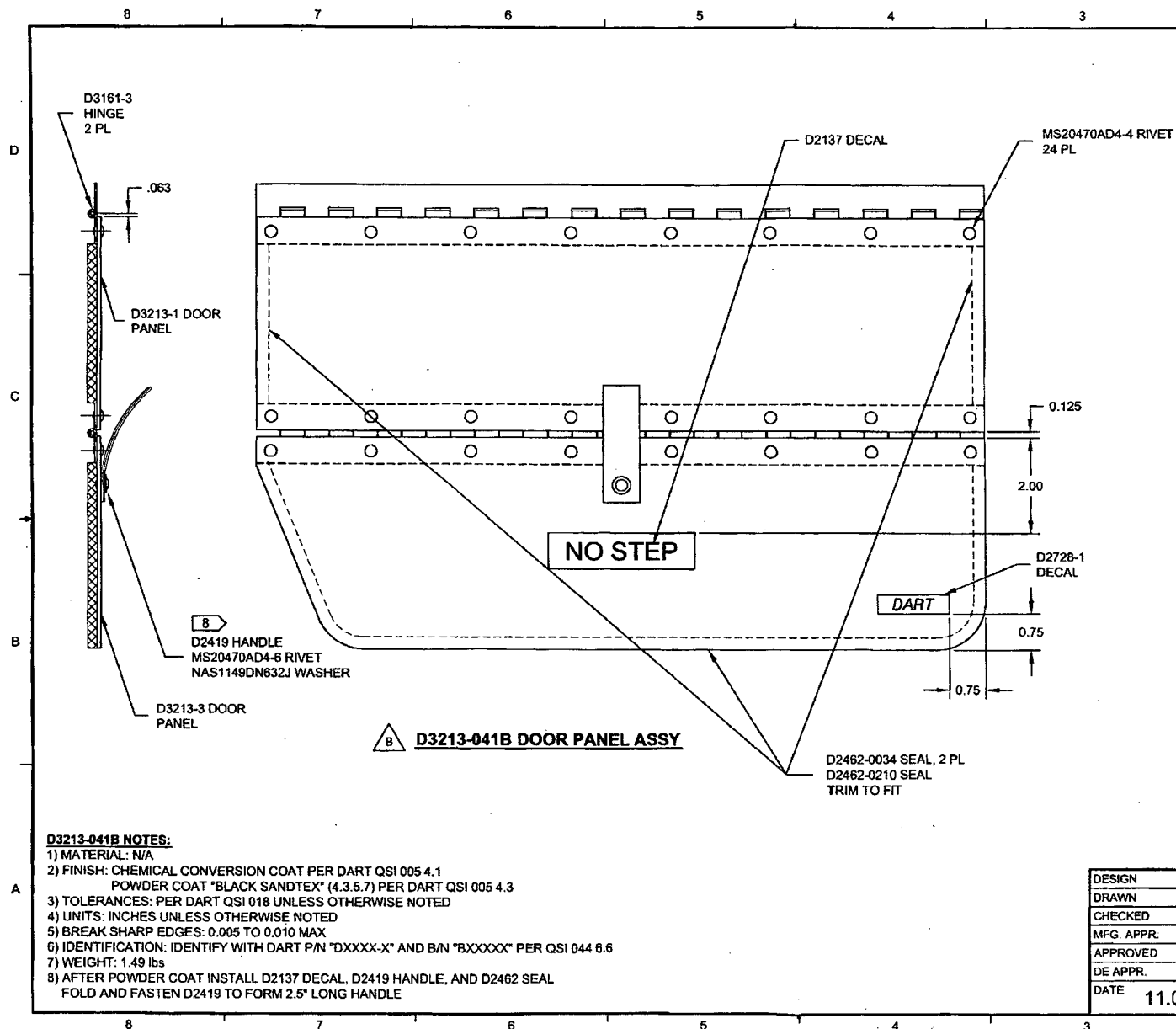
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



| QTY   | PART NUMBER   | DESCRIPTION          |
|-------|---------------|----------------------|
| -041B |               |                      |
| X     | D3213-041B    | DOOR ASSEMBLY, BLANK |
| 1     | D2419         | HANDLE               |
| 2     | D2462-0034    | SEAL                 |
| 1     | D2462-0210    | SEAL                 |
| 1     | D2728-1       | DECAL                |
| 1     | D2137         | DECAL                |
| 2     | D3161-3       | HINGE                |
| 1     | D3213-1       | DOOR PANEL           |
| 1     | D3213-3       | DOOR PANEL           |
| 1     | NAS1149DN632J | WASHER (OR AN960JD6) |
| 24    | MS20470AD4-4  | RIVET                |
| 1     | MS20470AD4-6  | RIVET                |

**RELEASED**  
2011-06-14

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | 9P       | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      | A        | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    | JP       | DRAWING NO.  | REV. B       |
| MFG. APPR. | B        | D3213  | SHEET 2 OF 4 |
| APPROVED   | JP       | TITLE  | SCALE        |
| DE APPR.   | JP       | DOOR ASSEMBLY  | NTS          |
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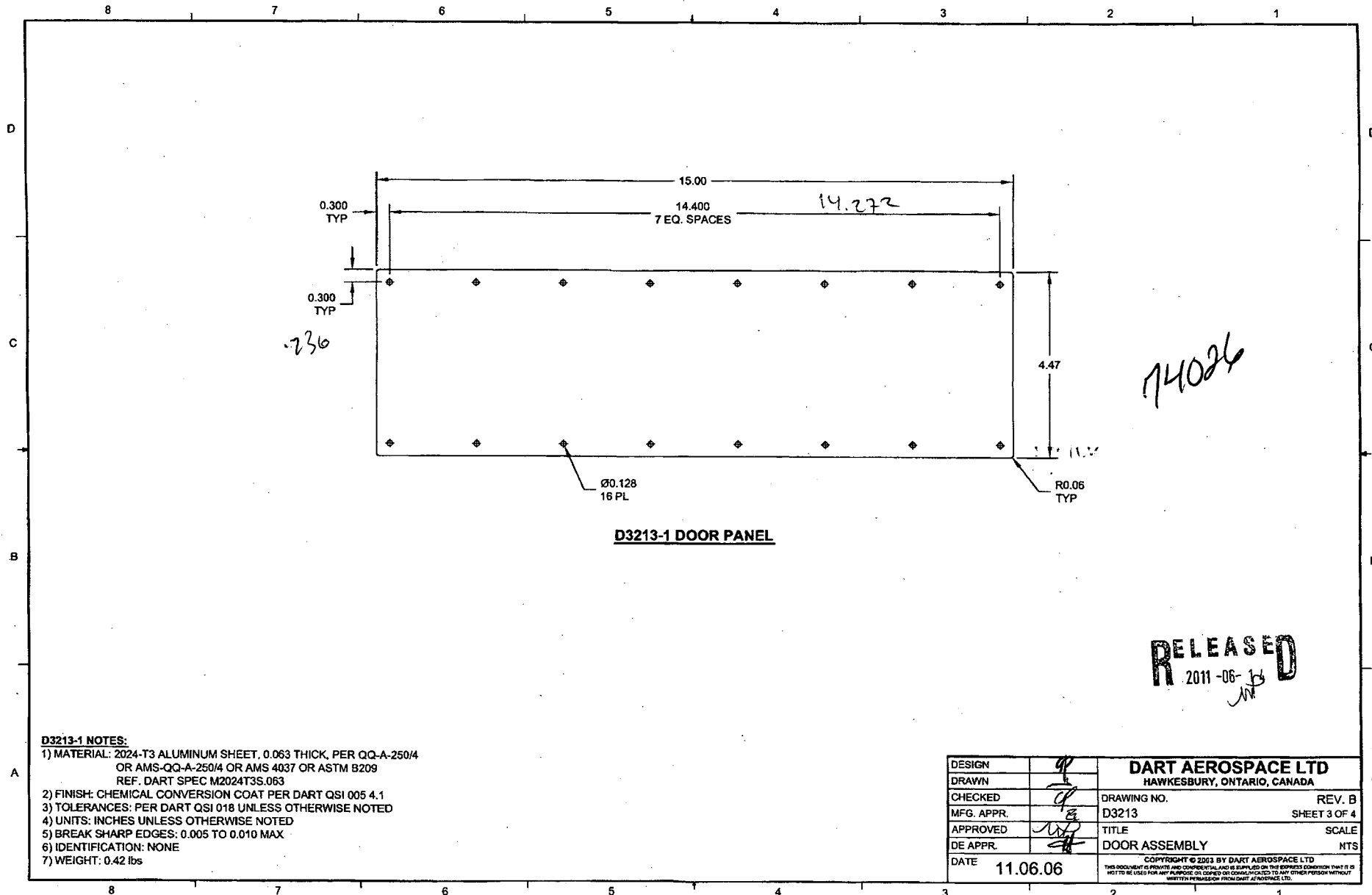
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
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**NOTE:** Date & initial all entries



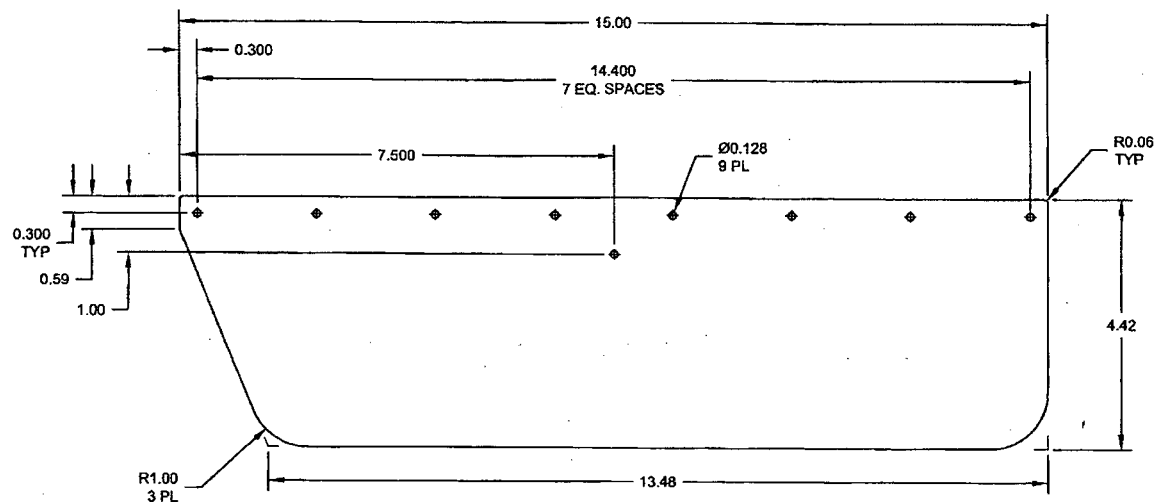
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



**D3213-3 DOOR PANEL**

**RELEASED**  
2011-06-13  
NR

**D3213-3 NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209  
REF. DART SPEC M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.39 lbs

|   |          |  |              |
|---|----------|--|--------------|
| DESIGN  | DP       | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN   | DP       | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED   | DP       | DRAWING NO.                            | REV. 8       |
| MFG. APPR.  | DP       | D3213                                  | SHEET 4 OF 4 |
| APPROVED  | DP       | TITLE                                  | SCALE        |
| DE APPR.  | DP       | DOOR ASSEMBLY                          | NTS          |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries